

Work Order ID 64076

Wednesday, November 24, 2010 8:35:31 AM

Page 1

Item ID: D3535-39

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 11/24/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535' ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304.040

B10-11-26

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/11/26

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64076

Wednesday, November 24, 2010 8:35:31 AM



Page 2

Item ID: D3535-39

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/24/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. <input type="checkbox"/> Identify as D3535-41 <input type="checkbox"/> Form Joggle on brake using Jig DT8158 as per Dwg D3535								
				SB 10/11/29					
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
				8, 10/11/29					
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	START TIME: 11:00 <input type="checkbox"/> OVEN TEMPERATURE:								
	320° FINISH TIME: 11:30								

13

x3

13

BL 10-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:35:35 AM

Page 1

Work Order ID: 64076



Parent Item: D3535-39



Parent Item Name: Wearshoe



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased											
						100	sf	88.4000	0.951	12.01263			
													

304/316 .040 Sheet

1810-11-25

Location

Loc Qty

Loc Code

MAT

84.4

115762

10.2

115953

74.2

MAT20

4

113062

1.398

115440

2.602

115953

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64077
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	*		T	
32.77	+/-0.010	32.77	0		T	
29.275	+/-0.010	29.275	*		T	
25.775	+/-0.010	25.775	0		T	
23.250	+/-0.010	23.250	*		T	
19.750	+/-0.010	19.750	0		T	
17.750	+/-0.010	17.750	0		T	
14.250	+/-0.010	14.250	0		T	
9.500	+/-0.010	9.500	0		T	
4.750	+/-0.010	4.750	2		T	
2.000	+/-0.010	2.000	0		V 1802	
5.00	+/-0.030	5.00	*		T	
9.00	+/-0.030	9.00	0		T	
28.00	+/-0.030	28.00	2		T	
Ø0.188	+0.005/-0.001	.192	*		V	
1.885	+/-0.010	1.887	*		V	
0.300	+/-0.010	.305	*		V	
0.300	+/-0.010	.306	*		V	
0.038	+/-0.010	.037	*		V	

Measured by:	RB
Date:	10-11-20

Audited by:	S
Date:	10/14/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

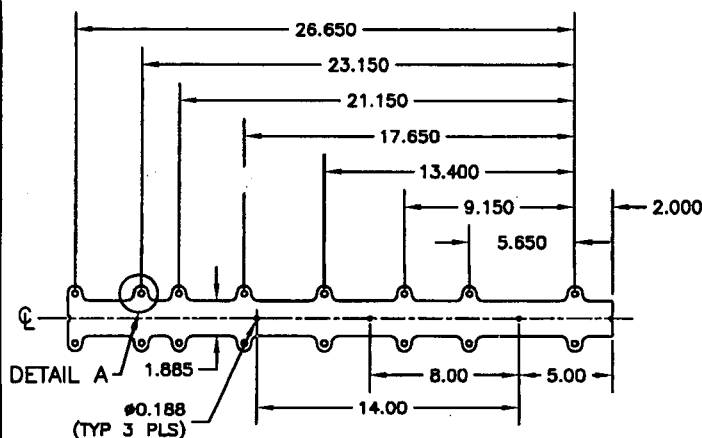
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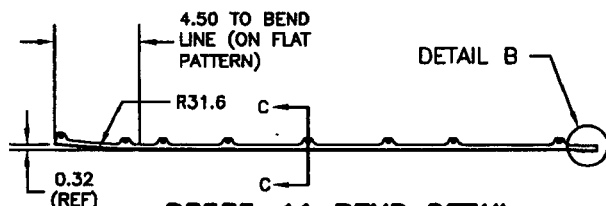
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 114074

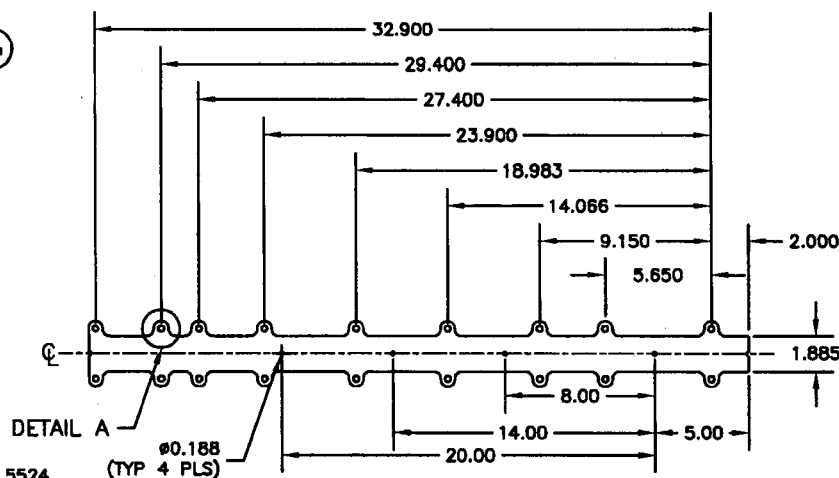
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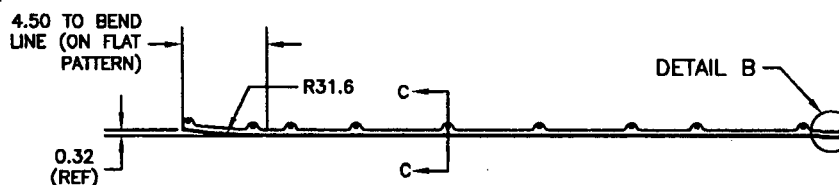
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	DATE
CB	PH	WEARSHOE	07.04.17
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 1 OF 7
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B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

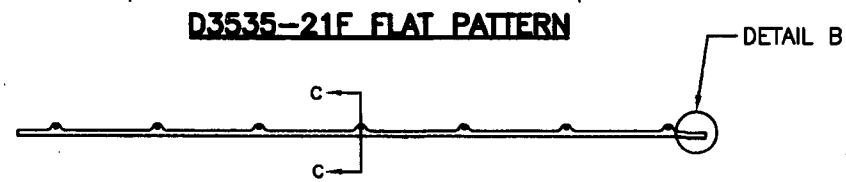
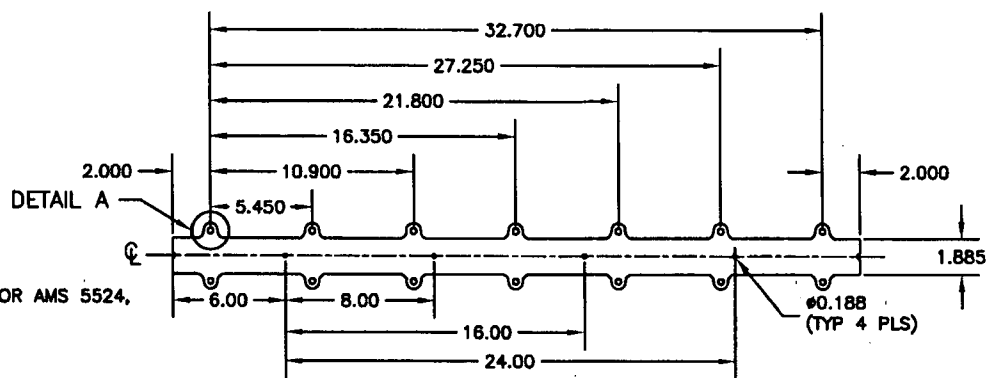
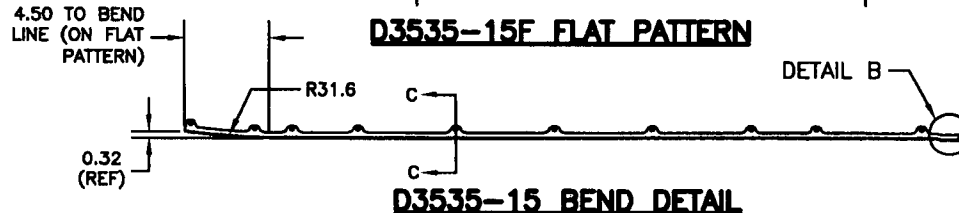
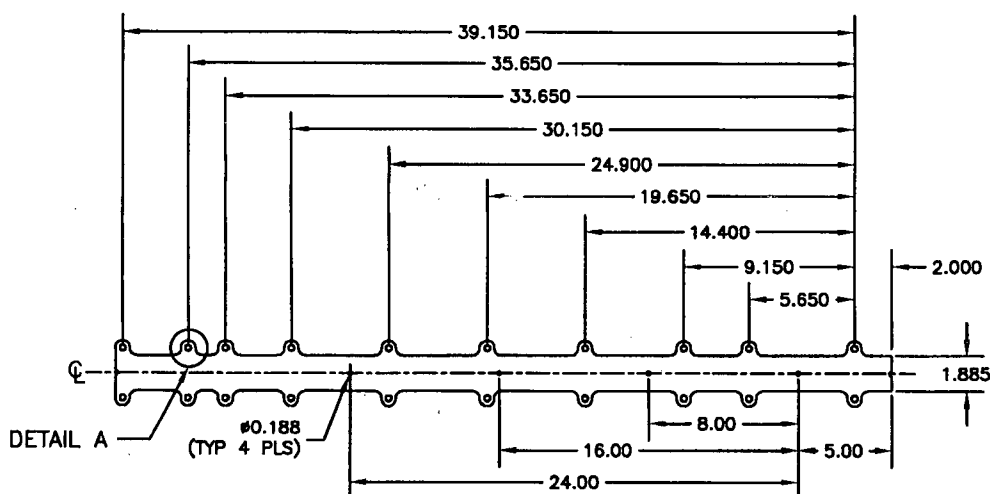
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#	#	D3535	SHEET 2 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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D3535-21F FLAT PATTERN

D3535-21 BEND DETAIL

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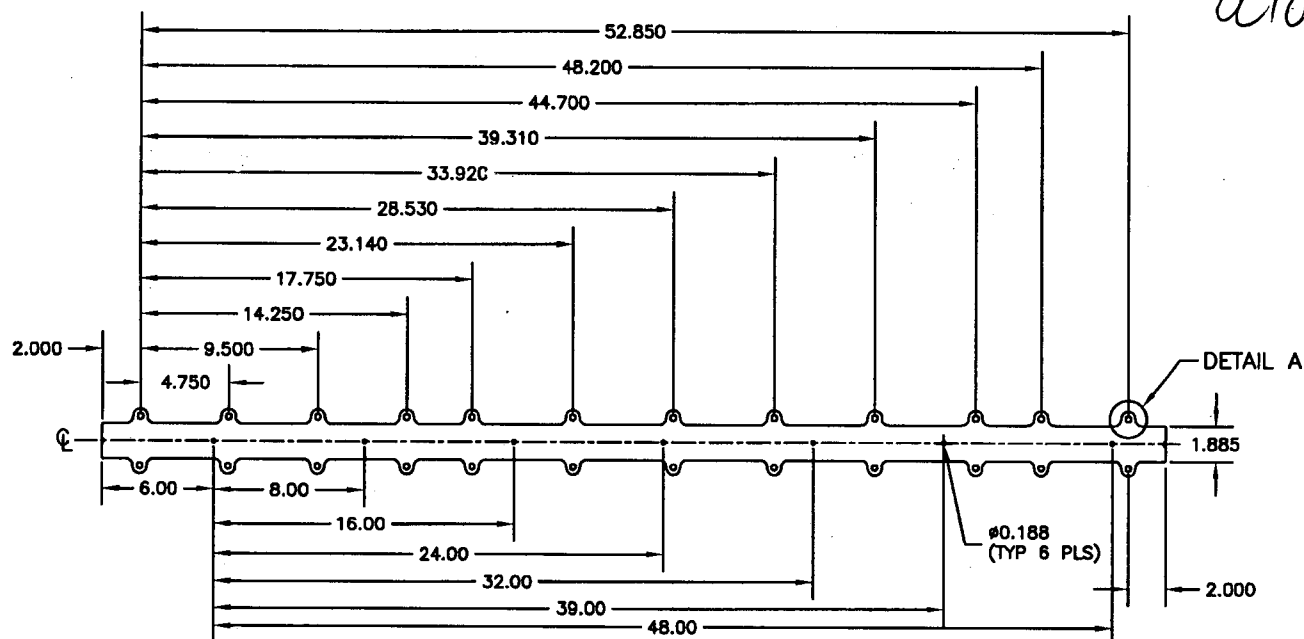
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DATE	TITLE	SCALE	
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07.04.24

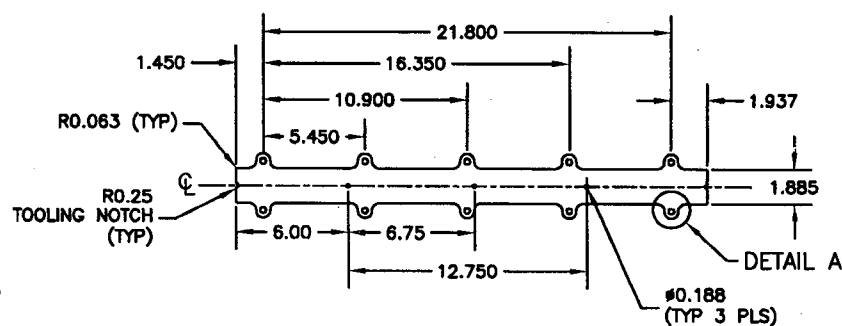
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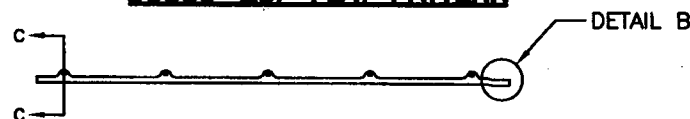
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

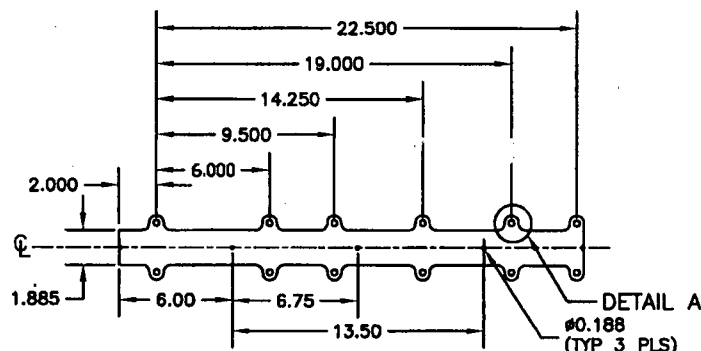
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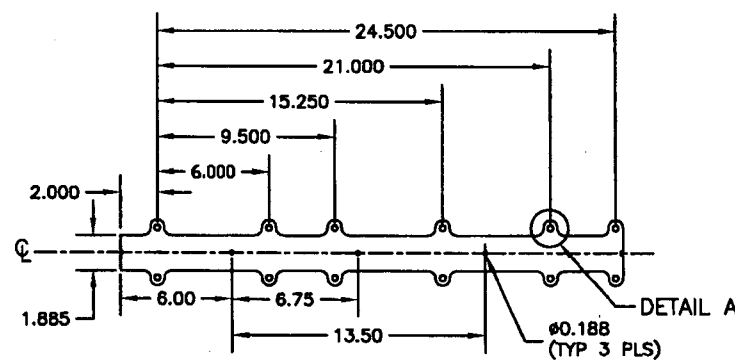
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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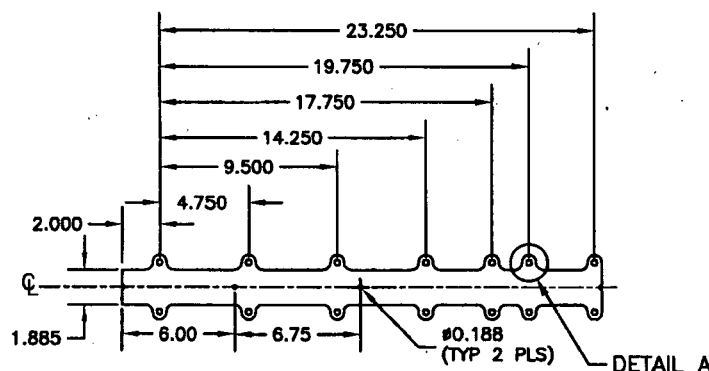
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
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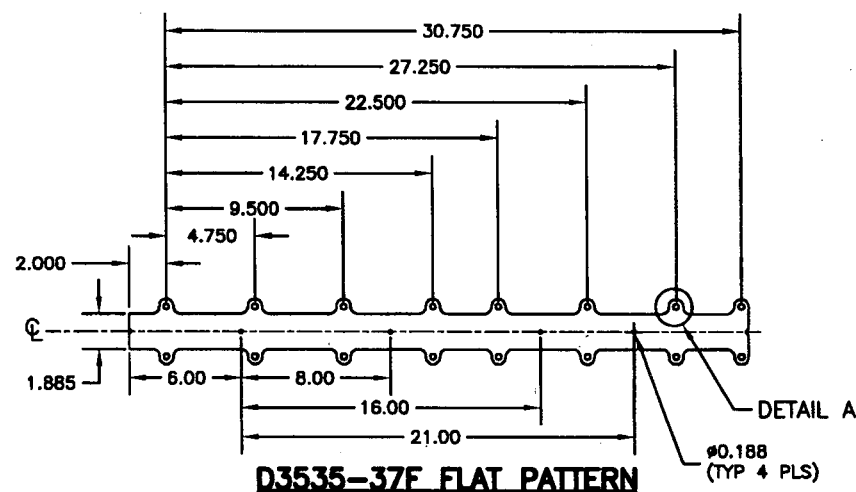
u/b 64076



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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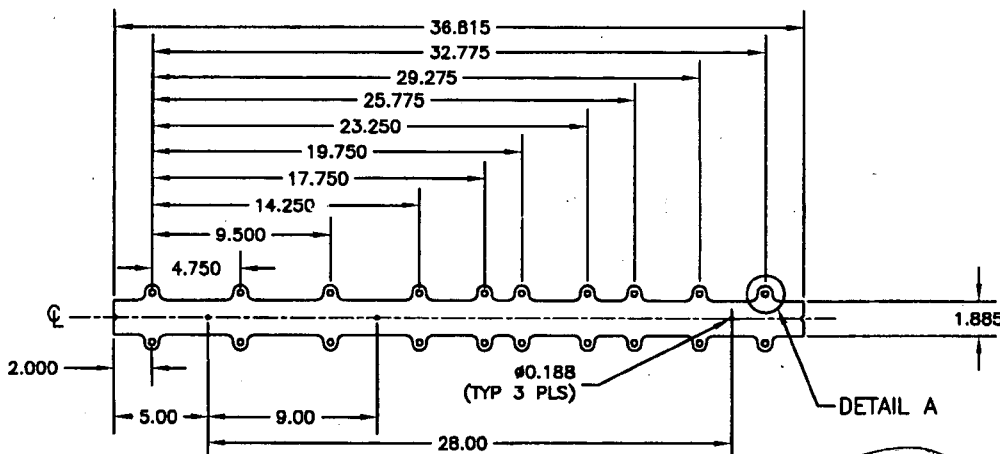
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		REV. B	SHEET 5 OF 7	

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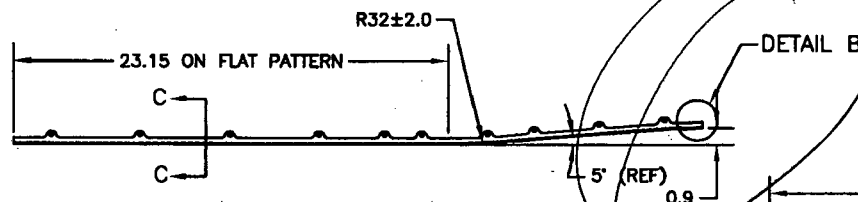
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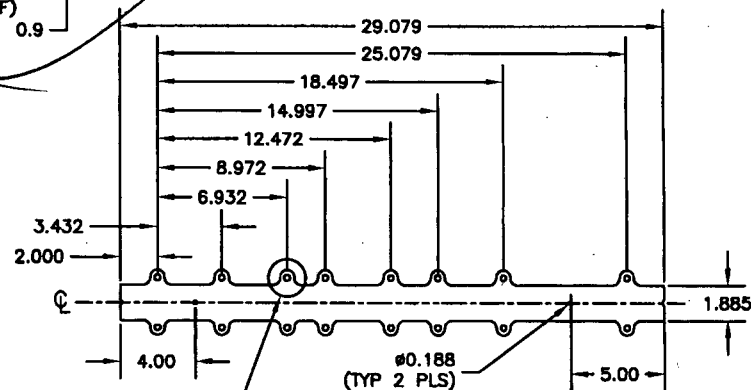
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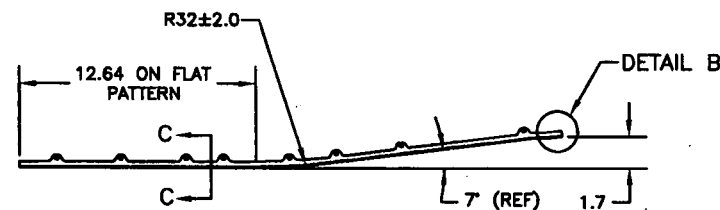
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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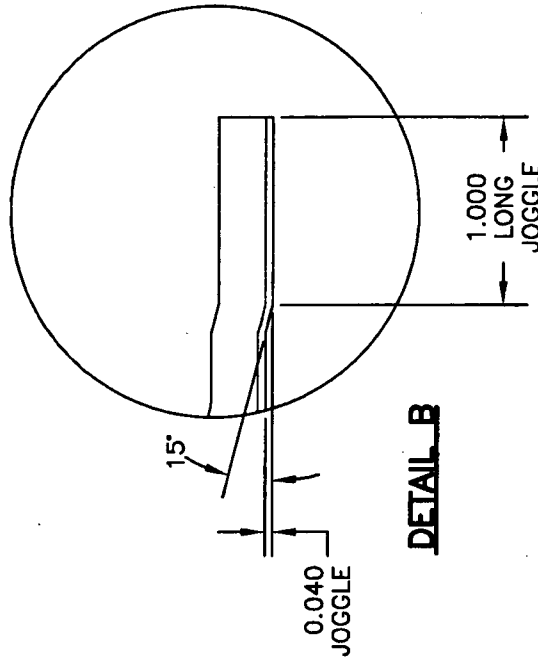
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DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
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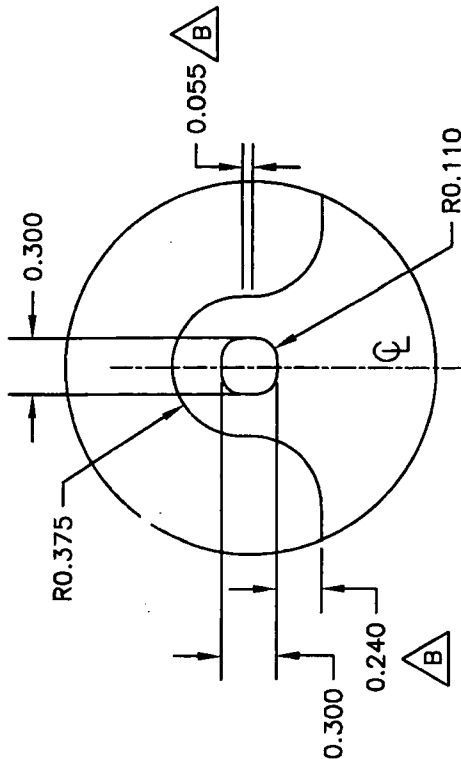
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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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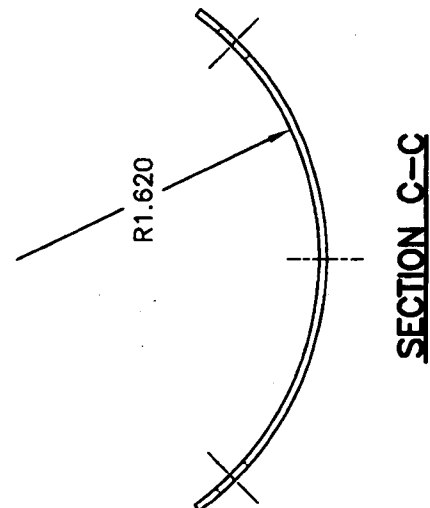
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DETAIL B



DETAIL A



SECTION C-C

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